

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010831**Date Inspected:** 07-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

FCAW welding of weld joints NSTL4-3B/L-41, 42 located inside PCMK north tower, lift 4, skin A, single diaphragm 116M to fit lug and stiffener to fit lug, respectively. Welder was identified as 053116. ZPMC QC was identified as CWI Tu Jun (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2133.

Bay 2

This QA Inspector proceeded to Bay 2 in response to ZPMC Inspection Notification # 4813 for magnetic particle inspection (MT) of the following:

This QA Inspector performed random visual inspection (VT) and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as FB3077-001. The weld designations reviewed were 003, 004, 006.

This QA Inspector performed random VT and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

member is identified as FB3076-001. The weld designations reviewed were 006, 019, 020.

This QA Inspector performed random VT and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as FB3074-001. The weld designations reviewed were 006, 019, 020.

This QA Inspector performed random VT of the area previously tested and accepted by ZPMC Quality Control personnel on the members identified as FB3017-001, FB3018-001, FB3043-001, FB3044-001, FB3075-001. This QA Inspector was unable to observe any of the weld numbers listed on ZPMC Inspection Notification # 4813. There were no ZPMC QC or ABF representatives present in Bay 2. This QA Inspector called ZPMC QA Inspector Zhang Wei (ZQA) on the phone. ZQA informed this QA Inspector that the weld numbers would be added to each member on 12/8/09 and Caltrans would be informed verbally of the members' readiness for inspection without issuing a new ZPMC Inspection Notification.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Dawson, Paul	QA Reviewer
